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D4436-045
Job Sheet 194019



DAS
21
9-02

Part No: D4436-045

Job Qty: 6 pcs

Part Name: Aft Inboard Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/25/19

Job Tracking No:

Due Date: 5/16/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D4436 REV.B IPP revA 11.10.06 new issue EC verified by:DD IPP RevB 11.12.22 per PA2 EC verified by:JLM
IPP REV:C 12.01.24 PER DWG REV.A DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		5/16/19	0.00	1.07	Waterjet - Flow		2/19/05/09
110	QC 2	6 pcs		5/16/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		2/19/05/09
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	6 pcs	5/16/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
125 Small Fab - 2 - B4B	6 pcs	5/16/19	0.00 1.17	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
130 Small Fab - Brake NC - B4B	6 pcs	5/16/19	0.08 0.83	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
150 QC 5	6 pcs	5/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
160 Handfinish - 1-1 Chemical-B4B	6 pcs	5/16/19	0.00 0.52	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	

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40
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MAY 10 2019

SMB
19/1/15

AUG 06 2019

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30
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AUG 06 2019

DAS
81
9-89

AUG 06 2019

				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
170 QC 7	6 pcs	5/16/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
180 Small Fab - 2 - B4B	6 pcs	5/16/19	0.00 1.17	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
185 QC 5	6 pcs	5/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
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				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
190 Powdercoat - 4 Black Sand - B4B	6 pcs	5/16/19	0.00 0.30	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
200 QC 3	6 pcs	5/16/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
202 Small Fab - 2 - B4B	6 pcs	5/16/19	0.00 1.17	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
205 QC 5	6 pcs	5/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
210 Packaging 3-1 - Stock - B4B	6 pcs	5/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PK ST 620
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	6 pcs	5/16/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS AUG 13 2019
				QC 21 - SA - 53	21 9-05

Part Op **100** - 1-Cut D4436-3 as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
125 - 1- Transfer drill holes as per dwg. 2-C"SINK AS PER DWG 3-TRANSFER 0.129 HOLES THRU (2 PLACES)
130 - (Bend/Assemble as per dwg)
150 - (QC5- Inspect part completeness to step on W/O)
160 - (Chemical Conversion Coat per QSI005 4.1)
170 - (QC7-Inspect Chemical Conversion Coat)
180 - Assemble as per dwg, do not install grommets and rubber seal.
185 - (QC5- Inspect part completeness to step on W/O)
190 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: 11:45am OVEN TEMPERATURE: 375° C
FINISH TIME: 12:00pm
200 - (QC8- Inspect parts - second check)
202 - Cut qty 1 to 3.8" Cut qty 1 to 10.00" Install rubber seals and grommets, as per dwg
205 - (QC5- Inspect part completeness to step on W/O)
210 - (Identify as per dwg & Stock Location: _____)
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	5.5120 sf (.689 ea)	100-Waterjet - Flow - 1	5 / 52 / 50
MS20426AD3-3	Rivet	32 Ea (4 ea)	180-Small Fab - 2 - B4B	5174201
MS20470AD4-3	Rivet, Universal Head	16 Ea (2 ea)	180-Small Fab - 2 - B4B	8080639
MS21075L08	Anchor Nut	16 Ea (2 ea)	180-Small Fab - 2 - B4B	2201015
D4441-1	Rubber Seal	9.2000 ft (1.15 ea)	202-Small Fab - 2 - B4B	5092167
MS35489-19	Grommet	8 Ea (1 ea)	202-Small Fab - 2 - B4B	5067899

ST422
GAC17

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	6	376	0
180-Small Fab - 2 - B4B	MS20426AD3-3	32	6,555	0
	MS20470AD4-3	16	3,884	0
	MS21075L08	16	170	0
202-Small Fab - 2 - B4B	D4441-1	9	320	0
	MS35489-19	8	58	0

Part Specifications

Specifications could not be found.

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FIRST ARTICLE INSPECTION CHECKLIST

Measured by:		JRB/12		Audited by:		DAS 40		Preliminary Approval:			
Date:		5/9/19		Date:		9-89		Date:			
Rev	Date	Change						Revised by	Approved		
A	15.10.14	New Issue						KJ	[Signature]		[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S179709



Part: D4436-045

Job No: 194019

Serial No/Batch: S179709

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 05/09/19